



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

647.7701

Job Sheet 169386



Part No: 647.7701

Job Qty: 10 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/8/17

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A2 IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off             |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                      |
| 90    | Start up Operation | 10 Ea  |            | 1/11/18  | 0.00      | 0.00    | Start Up Large Fab-1  |           | EL                   |
| 110   | Packaging          | 10 pcs |            | 1/11/18  | 0.00      | 0.00    | Packaging1-1          |           | EL                   |
| 120   | Large Fab          | 10 pcs |            | 1/11/18  | 0.00      | 4.37    | Large Fab 4           |           | EL                   |
| 130   | QC                 | 10 pcs |            | 1/11/18  | 0.00      | 0.00    | QC9                   |           | PD 18-01-10          |
| 140   | QC                 | 10 pcs |            | 1/11/18  | 0.00      | 0.00    | QC5                   |           | PD 18-01-10          |
| 150   | Outsource          | 10 pcs |            | 1/11/18  | 0.00      | 0.00    | Outsource3            |           | AT 18/02/02          |
| 160   | Packaging          | 10 pcs |            | 1/11/18  | 0.00      | 0.00    | Packaging2            |           | AT 18/02/02          |
| 170   | QC                 | 10 pcs |            | 1/11/18  | 0.00      | 0.00    | QC5                   |           | 38                   |
| 180   | SprayPaint         | 10 pcs |            | 1/12/18  | 0.00      | 0.80    | Spray Paint           |           | AS 11 FEB 14 2018    |
| 190   | QC                 | 10 pcs |            | 1/12/18  | 0.00      | 0.00    | QC14                  |           | 9-89 FEB 16 2018     |
| 200   | Packaging          | 10 pcs |            | 1/12/18  | 0.00      | 0.00    | Packaging3-1          |           | 21                   |
| 210   | QC21-SA            | 10 Ea  |            | 1/12/18  | 0.00      | 0.00    | QC21                  |           | 8AS 9-89 FEB 20 2018 |

Part Op 120 - 1- ASSEMBLE AND WELD AS PER DWG \*\*\*IMPORTANT DIMENSION IS 23.75" \*\*\*  
Descriptions: 150 - Issue P/O : 38767 C of C is required  
180 - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG PRIMER BATCH: 138791

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | 647.7710 -     | 10       | 6         | 0         | 0       |
|                       | 647.7712       | 10       | 40        | 0         | 0       |
|                       | 647.7713       | 10       | 8         | 0         | 0       |

### Part Specifications

Specifications could not be found.

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Dart Aerospace Ltd.

1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

**DART**  
AEROSPACE  
**S026169**



Strut Assembly

**647.7701****PART NO:****Revision:****Start up Operation****Operation:****Change No:**

Mfg Date: 12/21/17

Job No: 169386

## DISPOSITION

Rework ☐  
Scrap ☐  
Use-as-is ☐  
approved ☐

Skid-tube ☐  
Machining ☐  
Thermoforming ☐  
Large Fab ☐

Cross tube ☐  
Small Fab ☐  
Finishing ☐  
Composite ☐

Water Jet ☐  
Prod. Eng. Coord. ☐  
Rec/Store/Packaging ☐  
Supplier ☐

Engineering ☐  
Quality ☐  
Other ☐

QTY Effective :

MRB (QSI042) Approval

## Disposition

Completed By

Lead hand / Supervisor  
Approval VerificationQC / QA Coordinator  
Approval

## FAULT CATEGORY

Temperature/Cure ☐  
Set-up ☐  
BOM/Route ☐  
Broken/Damage/Defect ☐  
Inspection Incomplete/Unqualified ☐  
Contamination ☐  
Countersink ☐  
Cut Too Short ☐  
Instructions Incomplete/Unclear ☐  
Drill Holes ☐

Power Loss/Surge ☐  
Folio/Program ☐  
Grain ☐  
Weld ☐  
Wrong Stock Pulled ☐  
Out of Sequence ☐  
Off-set ☐  
Misabeled ☐  
Fit/Function ☐  
Misaligned/off center ☐

Positioned Wrong ☐  
Outside Dimensions ☐  
Over/Under tolerance ☐  
Part Incorrect ☐  
Part Lost/Missing ☐  
Part Moved ☐  
Drawing ☐  
Finish ☐  
Misread ☐  
Turning Sequence ☐

Substation

Process Improvement

Marks/Chatter

Past Expiry Date

Manufacturing Process

Misidentified

Past Due

OTHER :





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO038767**

**Supplier:** GRO002-VC  
Group Altech  
2455 Halpern  
St Laurent  
QC  
H4S 1N9 Canada  
Phone: 514-335-3666  
Fax: 514-335-3868

**PO No:** PO038767

**PO Date:** 1/11/18

**Due Date:** 1/22/18

**Purchase Order**  
**Revision:**

**Revision Date:**

**Ship-To Contact:** Lavoie, Chantal  
clavoie@dartaero.com

**E-MAILED**  
JAN 15 2018

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground

**Pymt Terms:** Net 30

**Freight Terms:**

**Special Comments:**

## **Items**

| Line Item | Job    | Part     | Description                                                                                                                                                  | Status | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
|-----------|--------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|----------|----------------|-------------------|---------|------------------|----------------|
| 1         | 169386 | 647.7701 | Strut Assembly<br>Issue P/O : _____ Group<br>Altech<br>CAD PLATE IAW QQ-P-416F<br>CLASS I TYPE II<br>note: cad plate should not be too<br>thick around tread | Firmed | 1/22/18  | 10 pcs         | 0 pcs             | 10 pcs  | \$6.00/pcs       | \$60.00        |
| 2         | 169387 | 647.7702 | Strut Assembly<br>Issue P/O : _____ Group<br>Altech<br>CAD PLATE IAW QQ-P-416F<br>CLASS I TYPE II<br>note: cad plate should not be too<br>thick around tread | Firmed | 1/22/18  | 10 pcs         | 0 pcs             | 10 pcs  | \$6.00/pcs       | \$60.00        |
| 3         | 169877 | 647.2511 | Nut<br>Issue<br>P/O: _____<br>Pasivate as per MIL-S-5002 TYPE 6<br>Certificate of conformaty is required                                                     | Firmed | 1/22/18  | 10 pcs         | 0 pcs             | 10 pcs  | \$2.3809523/pcs  | \$23.81        |
| 4         | 169400 | 647.8511 | Insert<br>-Issue P/O to Groupe Altech: P/O<br>-Passivate, MIL-S-5002 TYPE 6 AS<br>PER DWG<br>- Certificate of Conformity is required                         | Firmed | 1/22/18  | 11 pcs         | 0 pcs             | 11 pcs  | \$2.3809523/pcs  | \$26.19        |
| 5         | 169401 | 647.8512 | Insert<br>-Issue P/O to Groupe Altech: P/O<br>-Passivate, MIL-S-5002 TYPE 6 AS<br>PER DWG<br>- Certificate of Conformity is required                         | Firmed | 1/22/18  | 21 pcs         | 0 pcs             | 21 pcs  | \$2.3809523/pcs  | \$50.00        |

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1/15/2018

## PURCHASE ORDER

| Items                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |        |           |                                        |        |          |                |                   |         |                  |                |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|-----------|----------------------------------------|--------|----------|----------------|-------------------|---------|------------------|----------------|
| Line Item                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Job    | Part      | Description                            | Status | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
| 6                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 169271 | RB        | Jack Screw                             | Firmed | 1/22/18  | 3 pcs          | 0 pcs             | 3 pcs   | \$30.00/pcs      | \$90.00        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |        | T101338-3 | -Issue P/O to Groupe Altech: P/O       |        |          |                |                   |         |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |        |           | -Zinc plate, ASTM B633 TYPE 1          |        |          |                |                   |         |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |        |           | SC2                                    |        |          |                |                   |         |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |        |           | -Certificate of Conformity is required |        |          |                |                   |         |                  |                |
| Grand Total:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |        |           |                                        |        |          |                |                   |         |                  | \$310.00       |
| Order Notes                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |        |           |                                        |        |          |                |                   |         |                  |                |
| Procurement Quality Clauses<br>A005 right of entry<br>A012 chemical and physical test report<br>A016 personnel qualification<br>A017 raw material identification (as applicable)<br><br>A022 Apical Processing<br>A024 process certifications<br>A026 certification of material conformance<br><br>A041 quality management system<br>A042 dart notification by supplier<br>A043 retention of quality documents<br><br>A048 counterfeit parts avoidance, detection, mitigation and disposition program<br><br>A049 supplier awareness<br><br>Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit <a href="http://www.dartaerospace.com">www.dartaerospace.com</a> for further explanation. |        |           |                                        |        |          |                |                   |         |                  |                |

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# Certificat de Conformité / Certificate of Compliance

(005811-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9  
 Tel: 514-335-3666 Fax: 514-335-3868  
 www.groupaltech.com

## Bon de Livraison / Packing Slip

**005811- 1**

Livré à / Ship to

**DART AEROSPACE LTD**  
 1270 ABERDEEN STREET  
 HAWKESBURY, ON, K6A1K7  
 CANADA  
 Tel.: 613-632-5200 Fax.:

Client / Customer:

**DART AEROSPACE LTD**  
 1270 ABERDEEN STREET  
 HAWKESBURY, ON, K6A1K7  
 CANADA  
 BUYER:

| Date expédition<br>Ship date |                                                                            | Créé Par<br>Generated By                                                                                | Transport / No de Compte<br>Courier / Acc. No. | Bon de commande Client<br>Customer Purchase Order No. |                 |                   |               |                        |
|------------------------------|----------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------|------------------------------------------------|-------------------------------------------------------|-----------------|-------------------|---------------|------------------------|
| 22-Jan-2018                  |                                                                            | Curtis Anderson                                                                                         |                                                | PO038767                                              |                 |                   |               |                        |
| #Ligne<br>Line#              | No. de Série / # Pièce<br>Part Number / Line Item Details<br>Job # / Ref # | Description pièce(s)                                                                                    | CATG.<br>U/M                                   | Comm.<br>/Ordered                                     | Exp/<br>Shipped | Qté NC/<br>NC Qty | Qté<br>Scrap/ | À venir/<br>Back Order |
| 1                            | 647-7701<br>Rev.                                                           | 647-7701<br>CAD PLATE IAW QQ-P-416F<br>CLASS 1 TYPE 2<br>CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD | CADMIUM<br>CH                                  | 10                                                    | 10              | 0                 | 0             | 0                      |
| 2                            | 647-7702<br>Rev.                                                           | 647-7702<br>CAD PLATE IAW QQ-P-416F<br>CLASS 1 TYPE 2<br>CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD | CADMIUM<br>CH                                  | 10                                                    | 10              | 0                 | 0             | 0                      |
| 3                            | 647-2511<br>Rev.                                                           | 647-2511<br>PASSIVATION AS PER MIL-S-5002 TYPE 6                                                        | PASSIVATION<br>CH                              | 10                                                    | 10              | 0                 | 0             | 0                      |
| 4                            | 647-8511<br>Rev.                                                           | 647-8511<br>PASSIVATION MIL-S-5002 TYPE 6                                                               | PASSIVATION<br>CH                              | 11                                                    | 11              | 0                 | 0             | 0                      |
| 5                            | 647-8512<br>Rev.                                                           | 647-8512<br>PASSIVATION MIL-S-5002 TYPE 6                                                               | PASSIVATION<br>CH                              | 21                                                    | 21              | 0                 | 0             | 0                      |
| 6                            | RBT101338-3<br>Rev.                                                        | RBT101338-3<br>ZINC PLATE ,ASTM B633 TYPE 1 SC2                                                         | ZINC<br>CH                                     | 3                                                     | 3               | 0                 | 0             | 0                      |

## Notes Additionnelles / Additional Notes

CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD

Épaisseur réelle  
Actual Thickness

Inspecteur Qualité  
Quality Inspector

Réçu par  
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences  
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements  
 Our financial and legal responsibility will not be higher than the amount of invoice.